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RBEM652V3002102
Job Sheet 195970



Part No: RBEM652V3002102

Job Qty: 1 pcs

Part Name: Tail Gear Box Input Seal Exchange



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/3/19

Job Tracking No:

Due Date: 6/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 16692*

Note: DWG RBEM652V3002102 Rev A IPP Rev. A 19.05.29 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S194447

Part: RBEM652V3002102

Job No: 195970

Serial No/Batch: S194447

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
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Date: 06/27/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Small Fab - Issue SN	1 pcs	6/17/19		0.00	0.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
100	Small Fab - 1	1 pcs	6/17/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	6/17/19		0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	6/17/19		0.00	0.00	Packaging 3 - 1 - B4B		JUN 27 2019 DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
130	QC 21 - FG	1 pcs	6/17/19		0.00	0.00	QC 21 - FG - 21		JUN 27 2019 DAS 70 9-89
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 90 - Issue S/N.

Descriptions: 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1510-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBEM652V3002102-4 to RBEM652V3002102-3 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	90-Small Fab - Issue SN	5021040
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	100-Small Fab - 1	5163934
APP-1510-E	Case	1 Ea (1 ea)	100-Small Fab - 1	5191810
RBEM652V3002102-2	Bottom Foam use in case APP-1510-E	1 Ea (1 ea)	100-Small Fab - 1	5191809
RBEM652V3002102-3	Top Foam use in case APP-1510-E	1 Ea (1 ea)	100-Small Fab - 1	5191810
RBEM652V3002102-4	Content Placard	1 (1 ea)	100-Small Fab - 1	5191021
RBEM652V3002102-5	Guide Assembly <i>on order</i>	1 pcs (1 ea)	100-Small Fab - 1	5194238
RBEM652V3002102-7	Exchange Assembly <i>on order</i>	1 pcs (1 ea)	100-Small Fab - 1	5194240

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - Issue SN	RB41011	1	312	0
	97524A032	4	265	0
100-Small Fab - 1	APP-1510-E	1	2	0
	RBEM652V3002102-2	1	0	0
	RBEM652V3002102-3	1	0	0
	RBEM652V3002102-4	1	0	0
	RBEM652V3002102-5	1	0	0
	RBEM652V3002102-7	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 6/3/19 3:08 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



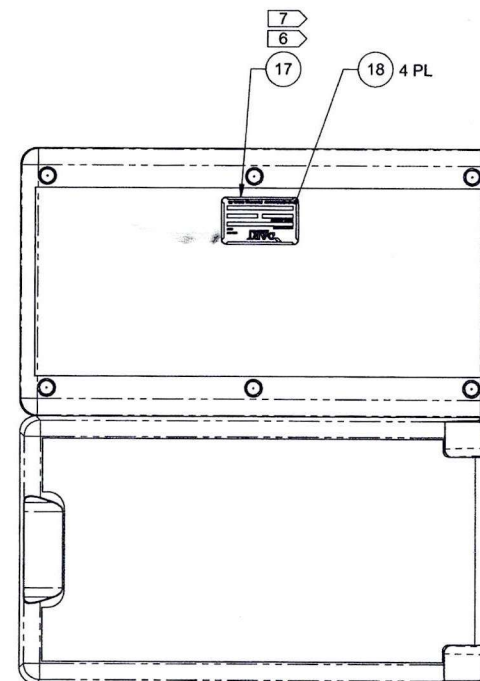
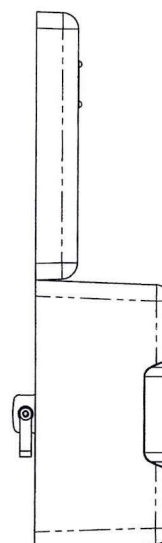
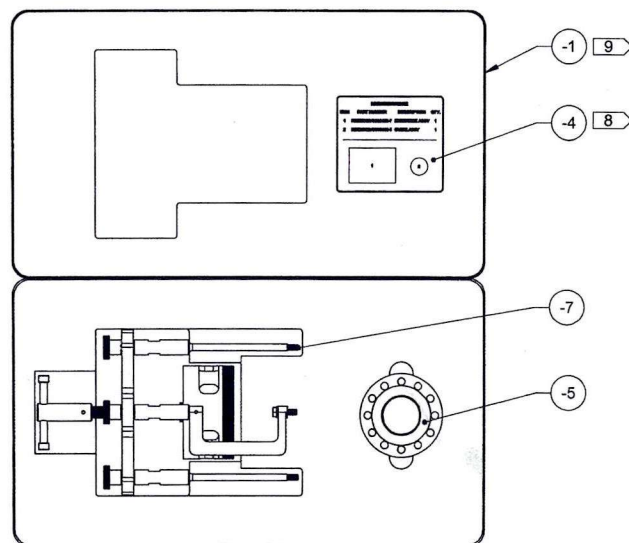
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM #	QTY	PART #	PART TITLE
-1	1	RBEM652V3002102-1	PACKAGING ASSY
-4	1	RBEM652V3002102-4	CONTENT PLACARD
-5	1	RBEM652V3002102-5	GUIDE ASSEMBLY
-7	1	RBEM652V3002102-7	EXCHANGE ASSEMBLY
17	1	RB41011	DART PLACARD
18	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.



RBEM652V3002102 TAIL GEAR BOX INPUT SEAL EXCHANGE

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: ENGRAVE THE T/N ON THE DART PLACARD WHERE INDICATED
- 7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 8) HOT GLUE THE CONTENT PLACARD ONTO THE TOP FOAM
- 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE SUPERCEDES RBEM652V3002101-M	19-742	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM	REV. A	
CHECKED	KPT	TOOL PART # RBEM652V3002102	
MFG. APPR.	JFC	SHEET 1 OF 17	
APPROVED	WJP	TITLE TAIL GEAR BOX INPUT SEAL EXCHANGE	
DATE 2019-05-24		SCALE NTS	
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